

Work Order ID 61971

Monday, September 13, 2010 11:32:56 AM



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Item ID:	D3687-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	MOUNT					
Start Date:	9/13/2010	Start Qty: 3.00		Cust Item ID:		
Required Date:	9/13/2010	Req'd Qty: 3.00		Customer:		
Reference:						

Approvals:	Process Plan:		Date:	Tooling:	Date:	Run	Start	
	QC:		Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3687	Rev C								

126 QC5- Inspect part completeness to step on W/O 0.00
 QC Memo 0.00 *8/10/10* *x3*
 Quality Control INSPECT PARTS PER NCR10-330

128 0.00
 Small Fab Memo 0.00 *= 7 m.k 10/09/13* *(3X)*
 Small Fab OPEN HOLES TO CORRECT SIZE PER NCR10-330

129 QC5- Inspect part completeness to step on W/O 0.00
 QC Memo 0.00 *8/10/09/14* *(x3)*
 Quality Control

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Item ID: D3687-1

Accept

Setup Start

Revision ID:

Stop

Item Name: MOUNT

Start Date: 9/13/2010 Start Qty: 3.00

Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 078

0.00



Packaging

Memo

0.00

Packaging

RE-IDENTIFY USING NEW B/N

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/15 (3)

10/09/15

mf
10-9-15

Picklist Print

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Work Order ID: 61971



Parent Item: D3687-1



Parent Item Name: MOUNT

Start Date: 9/13/2010

Required Date: 9/13/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A New Issue 08-01-15 JLM Verified By:EC
 IPP Rev:B Added Contion H-900 JLM Verified By:DD IPP REV
 C: ADDED QC6 10.09.09 JLM VERIFIED BY DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3687-1		Manufactured	No				Each	3.0000		3			
MOUNT													

Location

Loc Qty

Loc Code

ST080

3

51097

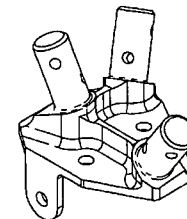
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56462

2

B56462 +2
 B51097 +1
 8/10/02/00

61971



RELEASED
2009-09-22

D3687-1 MOUNT

- NOTES:**
 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.81 lb
 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

C	0.555 WAS 0.50 (ZN B8-1); 1.373 WAS 1.375 (ZN A8-1, A8-2); ADD 0.620 (ZN B7-1) PER NCR09-084; UPDATE NOTE 8 TO REF QSI (ZN A6-1, B3-2); Ø0.257 WAS Ø0.250 (ZN A6-1, B7-1, B7-2)	RF	09.08.26
B	CHANGE TO 17-4PH H-900 (ZN A6-1 & B3-2); R0.032 WAS R0.015 (ZN C7-1 & C7-2); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	97	DRAWING NO.	REV. C
MFG. APPR.	21	D3687	SHEET 1 OF 2
APPROVED	142	TITLE	SCALE
DE APPR.		MOUNT	NTS
DATE	09.08.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR CORRECTIONS COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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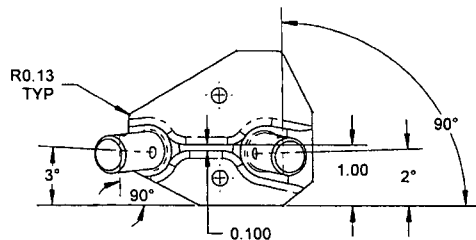
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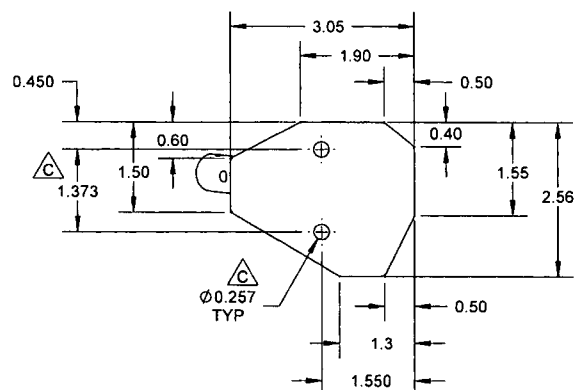
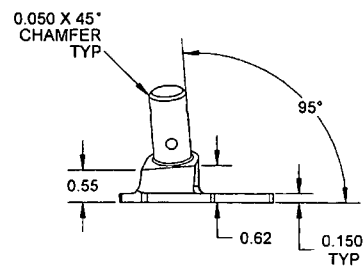
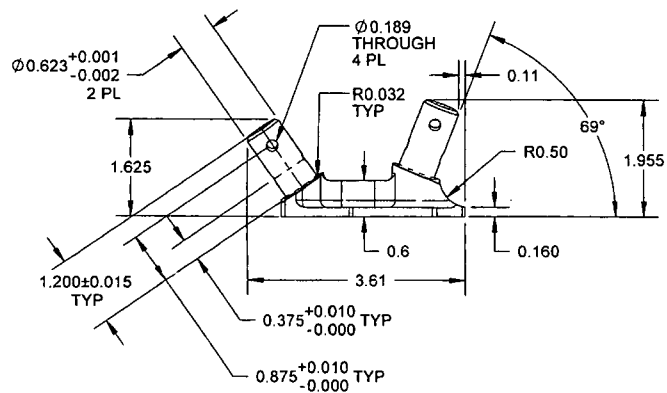
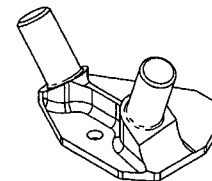
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61971



NOTES:

- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.64 lb
- 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

**D3687-3 MOUNT**

RELEASED
2009-09-22

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	GP	DRAWING NO.	REV. C
MFG. APPR.	GP	D3687	SHEET 2 OF 2
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	MOUNT	NTS
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1

Jason Murdoch

From: David Shepherd [dshepherd@dartaero.com]
Sent: Thursday, September 02, 2010 3:52 PM
To: 'Marc Bellavance'
Cc: 'Jason Murdoch'
Subject: RE: D205-770-011 Replacement Engine Mount Kit
Attachments: image002.jpg

Yes ... It is acceptable to open up the holes slightly. I do not feel an LPI is required after the rework.

David

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: Thursday, September 02, 2010 1:43 PM
To: 'David Shepherd'
Cc: 'Jason Murdoch'
Subject: FW: D205-770-011 Replacement Engine Mount Kit
Importance: High

REFERENCE ONLY

David,

Can you please have a look at this issue and advise.

Per Jason's investigation, the 0.189" holes on P/N D3687-1 are indeed too small (0.185" to 0.187") on pretty much all the parts we have in stock and therefore, it is impossible to insert the required bolts through.

Funny thing is, 2 legs out of 3 are assembled prior to packaging and it seems to Jason and me that the holes might have been reworked to tolerance during assembly. However, there is no non-conformance reported on the W/O's, no sign offs on the rework whatsoever.

We need to ship a replacement kit to Day Aviation who are not willing to rework the kit themselves ASAP per Eagle.

Question is: can manufacturing has your authorization to rework the part so we can ship the Kit to our customer? Also, is LPI required after the rework?

Thanks,

Marc Bellavance
Mechanical Designer/Technical Support

DART aerospace Ltd.

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Fax: 613-632-9311

E-mail: mbellavance@dartaero.com

Web: www.dartaero.com



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From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: September 2, 2010 11:27 AM